

Work Order ID 91545

91545

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October-12-12 11:32:43 AM

Item ID: D3488-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade Fitting Assembly, RH
 Start Date: 10/11/12 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 10/26/12 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12-10-12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3488	Rev B								
100	DOOSAN LATHE	0.00							
100									
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Dwg DSK 101 & Folio FA6272-Deburr								
			DAS 13 9-89	12/11/11					
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control			DAS 13 9-89	12/11/11					
120	HAAS CNC VERTICAL MACHINING #1	0.00							
120									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA627 & Dwg D34882-Deburr								
			B. 12/11/05						DAS 08 9-89

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 Required Date: 10/26/12 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>ML 12/11/05</i> <i>L.A 12/11/05</i>			<i>12</i>	<i>0</i>		<i>DAS</i> <i>12/11/05</i>
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>ML 12/11/05</i>			<i>12</i>	<i>0</i>		<i>DAS</i> <i>12/11/05</i>
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>12</i>	<i>26</i>	<i>12-11-12</i>	

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 7:15	0.00							
	FINISH TIME: 7:45								
	3200F								
170	QC3- Inspect Part Finish	0.00							
170									
QC									
Quality Control	Memo								
180	HandFinishing	0.00							
180									
HandFinish									
Hand Finishing	Memo								
	Install Inserts as per Dwg D3488								

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 Start Date: 10/11/12 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 10/26/12 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>EP-2</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12.0 12-11-21



x12 of 14 12/11/21

12/11/22

ME 12-11-21

Picklist Print

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Work Order ID: 91545

Parent Item: D3488-042

Start Date: 10/11/12

Required Date: 10/26/12

Parent Item Name: Blade Fitting Assembly, RH

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM
IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225 INSERT		Purchased	No				Each	4,072.0000		48		12/11/12	

Location	Loc Qty	Loc Code
FG	100	
118520	100	
FP-B	2174	
122290	2174	
ST282	1798	
100896	135	
111529	27	
118520	636	
122333	1000	

D6103-003
Round Billet, Aluminum

Manufactured No

Each 24.0000

12

Location	Loc Qty	Loc Code
MAT043	24	
82262	2	
83408	9	
87256	1	
89160	12	

91866

12 SA 12/11/11

DART AEROSPACE LTD	Work Order:	91545
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

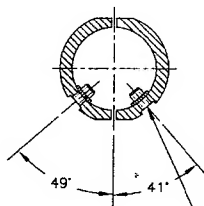
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.150	/		SA-4	U/L
Ø2.780	+/-0.005	2.784	/			
Ø3.125	+/-0.010	3.123	/			
Ø3.346	+/-0.010	3.347	/			
0.125 x 45°	+/-0.010 x +/-0.1°	.125 x 45°	/			
8.000	+0.030/-0.000	8.010	/		SA-3	U/L
9.250	+/-0.010	9.252	/		SA-3	
0.188	+/-0.010	.187	/			
R0.032	+/-0.010	R.031	/		R.G.	
R0.062	+/-0.010	R.060	/		R.G.	
Ø0.297	+0.005/-0.001	.299	/			
Ø0.430	+/-0.010	.431	/			
0.100	+/-0.010	.103	/			
0.125	+/-0.010	.129	/			
2.620	+/-0.010	2.620	/			
3.500	+/-0.010	3.500	/			
1.005	+/-0.010	1.005	/			
Ø0.484	+0.005/-0.001	.485	/			
1.180	+/-0.010	1.180	/			
3.150	+/-0.010	3.150	/			
3.070	+/-0.010	3.070	/			
R0.063	+/-0.010	R.060	/		R.G.	

DART AEROSPACE LTD		Work Order:	91545
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	Ø0.509	✓		Vern	GA-01
0.750	+/-0.010	0.758	✓		H-6	31006
1.500	+/-0.010	1.500	✓		Vern	GA-01
11.18	+/-0.030	11.179	✓		H-6	31006
R0.062	+/-0.010	R0.062	✓		R-6	ref.
0.125	+/-0.010	0.120	✓		Vern	GA-01
0.590	+/-0.010	0.587	✓		H-6	31006
0.793	+/-0.010	0.798	✓		"	"
1.351	+/-0.010	1.354	✓		"	"
1.317	+/-0.010	1.313	✓		Vern	GA-01
1.802	+/-0.010	1.802	✓		H-6	31006

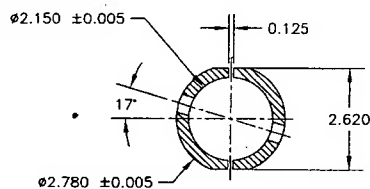
Measured by:	DAS 08 2-89	Audited by:	DAS 14 2-89	Prototype Approval:	N/A
Date:	12/11/05	Date:	12/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



SECTION A-A

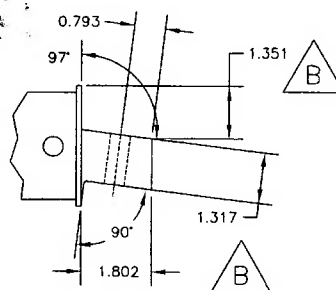
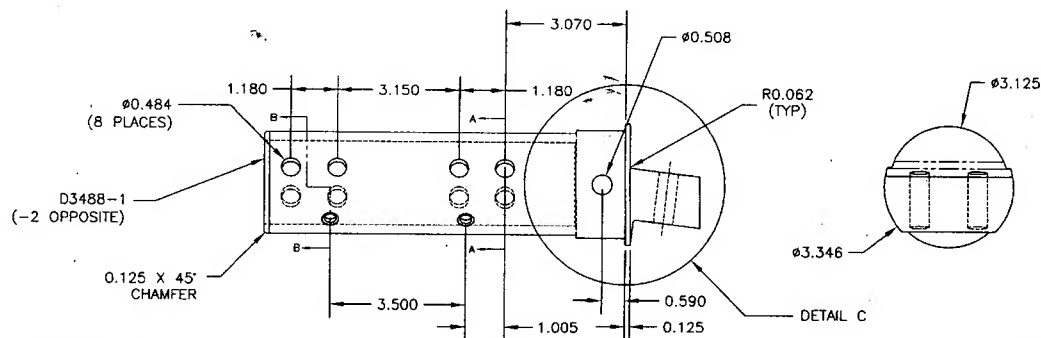
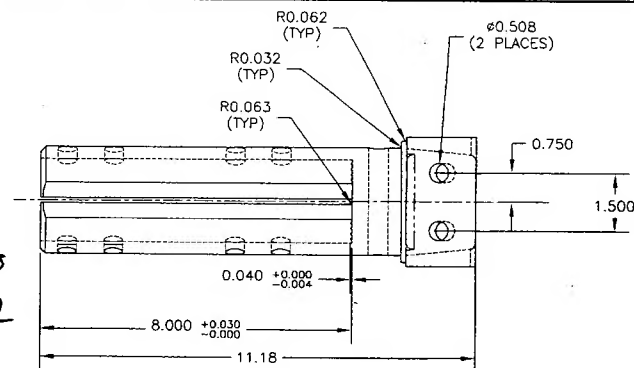
D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ASSIGNMENT
WITHOUT NOTICE
WORK ORDER
NO. 91545 MCG
12-10-12



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
PER OS
EIN #739

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B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED A	APPROVED A	DRAWING NO. D3488
DATE 06.03.15	TITLE BLADE FITTING	REV. B SHEET 1 OF 1 SCALE 1:3